

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
21 March 2002 (21.03.2002)

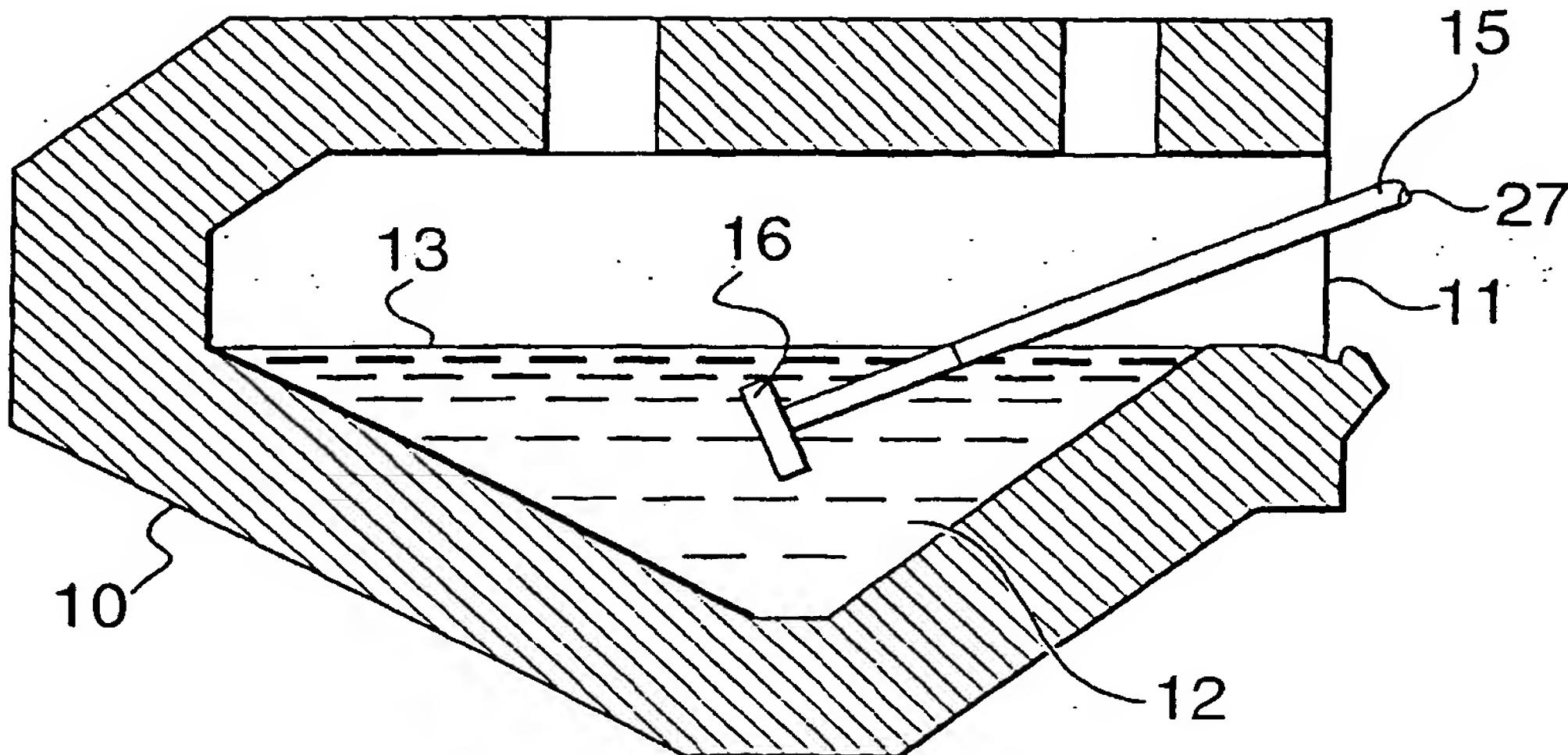
PCT

(10) International Publication Number
WO 02/22900 A2

- (51) International Patent Classification⁷: **C22B 21/06**
- (21) International Application Number: **PCT/CA01/01293**
- (22) International Filing Date: 10 September 2001 (10.09.2001)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data: 60/232,071 12 September 2000 (12.09.2000) US
- (71) Applicant (*for all designated States except US*): **ALCAN INTERNATIONAL LIMITED [CA/CA]**; 1188 Sherbrooke Street West, Montreal, Québec H3A 3G2 (CA).
- (72) Inventors; and
- (75) Inventors/Applicants (*for US only*): **BILODEAU, Jean-François [CA/CA]**; 3597, Angers, Jonquière, Québec G7X 2E2 (CA). **KISS, Laszlo, Istvan [CA/CA]**; 130 rue Marco, Chicoutimi, Québec G7G 4T3 (CA). **LAKRONI, Carl [CA/CA]**; 129, Panoramique, Chicoutimi, Québec G7J 1H7 (CA).
- (74) Agents: **EADES, Norris, M. et al.**; Kirby Eades Gale Baker, Box 3432, Station D, Ottawa, Ontario K1P 6N9 (CA).
- (81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, L.C., LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.
- (84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).
- Published:
— without international search report and to be republished upon receipt of that report

[Continued on next page]

(54) Title: PROCESS AND APPARATUS FOR ADDING PARTICULATE SOLID MATERIAL TO MOLTEN METAL



WO 02/22900 A2

(57) Abstract: An apparatus is provided for the treatment of molten metal, e.g. aluminum, with a particulate treatment agent and a gas. This includes a vessel for holding molten metal, a rotary device for breaking up particulate treatment agent and gas within the molten metal and for dispersing particulate treatment agent and gas within the molten metal contained in the vessel and means for supplying the particulate treatment agent and gas to the rotary device. The rotary device includes a hollow shaft having a rotor with an axial opening fixed to the discharge end of the shaft, this rotor being in the form of an annular plate with a plurality of radially mounted upwardly directed blades projecting from the top face of the annular plate and a plurality of radially mounted downwardly directed blades projecting from the bottom face of the annular plate.



For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

PROCESS AND APPARATUS FOR ADDING PARTICULATE SOLID
MATERIAL TO MOLTEN METAL

Technical Field

This invention relates to a process and apparatus
5 for the treatment of molten metals and, more
particularly, the addition of salt flux to aluminum in
melting and holding furnaces.

Background Art

Treatment of molten aluminum by gases and more
10 recently by salt fluxes in large melting and holding
furnaces incorporating stirring of the molten metal has
been proposed. A typical embodiment of such a device
is described in the article "Theoretical and
Experimental Investigation of Furnace Chlorine Fluxing"
15 by Celik and Doutre in Light Metals 1989, published by
the Minerals, Metals and Materials Society in 1988
(pages 793 to 800) in which an impeller positioned at an
angle within the furnace is used to stir the metal in a
holding furnace. A chlorine gas is added through a hole
20 in the shaft and is entrained by the circulating metal
and dispersed in the furnace. The article "Improving
Fluxing of Aluminum Alloys" by Beland et al in Light
Metals 1995, published by the Minerals, Metals and
Materials Society in 1995 (pages 1189 to 1195)
25 discloses the addition of salt flux with stirring for
treatment of metal in a furnace.

Treatment of molten aluminum using salt fluxes in
crucibles (for example those used for transporting
molten aluminum) has been proposed. Various rotary
30 devices have been proposed for introducing solids
and/or gases into molten metal in such crucibles to

perform various treatments. European Application EP 0396267, published November 7, 1990 describes a system for crucible fluxing using a rotary disperser on a vertically mounted shaft into which a gas/powder mixture is fed. The disperser includes an internal structure of compartments separated by blades. It has an open bottom and as such causes metal to be pumped through and ejected from the sides of the rotor.

Another form of device for dispersing flux in a molten metal bath is described in laid open Japanese Application 1988-193136, published July 28, 1988. This includes an annular rotor on a vertically mounted shaft with mixing flutes on the outer periphery thereof.

European Application EP 0395138 published October 31, 1990 describes another device for dispersing materials in molten metal using a rotary system. A salt/gas mixture is injected at the underside of a generally conical injector on a vertically mounted shaft having no blades or similar shearing devices.

Canadian Application CA 2,272,976, published November 27, 1999 describes a system for treatment of smelter metal in transport crucibles to reduce alkalis, by using stirrers on vertically mounted shafts. Various stirrers are disclosed, with blades mounted on the underside of a conical hollow rotor, and also including vertical blades on a portion of the upper conical surface.

It is an object of the present invention to provide an improved rotary dispersing system for adding a powder/gas mixture to molten metal which is particularly well adapted for injecting a salt flux into molten aluminum in a melting or holding furnace.

Disclosure of the Invention

According to one aspect of this invention there is provided an apparatus for the treatment of molten metal with a particulate treatment agent and a gas. This

5 includes a vessel for holding molten metal, a rotary device for breaking up particulate treatment agent and gas within the molten metal and for dispersing particulate treatment agent and gas within the molten metal contained in the vessel and means for supplying

10 the particulate treatment agent and gas to the rotary device. The rotary device comprises a hollow shaft having a rotor with an axial opening fixed to the discharge end of the shaft, this rotor comprising an annular plate with a plurality of radially mounted

15 upwardly directed blades projecting from the top face of the annular plate and a plurality of radially mounted downwardly directed blades projecting from the bottom face of the annular plate.

According to a preferred feature of the invention

20 the vessel is an aluminum melting or holding furnace and the rotary device is mounted on a carrier and can be moved in and out of an opening in the furnace. For use in this manner, the system is designed such that the rotary device can be operated with the axis of the

25 hollow shaft at an angle of about 20-40° to the horizontal. The carrier may be fixed adjacent to a specific opening in the furnace made for access by the rotor and shaft or it can be a mobile unit and access to the furnace is made through the normal door used for

30 charging such a furnace.

Regardless the orientation of the rotary device within the vessel, it will be understood that the top face of the annular plate with the upwardly projecting

blades is the face adjacent the hollow shaft, while the bottom face of the plate with the downwardly projecting blades is the face opposite the top face.

It is particularly preferred that the apparatus be
5 located within the furnace so that all parts of the rotor are located at least 30 cm from any interior surface of the furnace.

Particularly when it is desired to inject a
solids/gas mixture at an angle as described above,
10 special care is required to assure that proper mixing
and dispersal of the solids/gas mixture takes place.

According to a further preferred embodiment of the invention, a further annular plate is fixed below the radially mounted blades that project downwardly from
15 the first mentioned annular plate. Thus, the rotor comprises an upper annular plate and a lower annular plate with a plurality of radially mounted, upwardly directed blades projecting from the top face of the upper annular plate and a plurality of radially mounted
20 blades fixed between the upper and lower annular plates.

The lower annular plate preferably has a central opening communicating with the interior between the two plates.

25 In both of the above embodiments of the invention, the upwardly projecting radially mounted blades serve an important function. Thus, the downwardly directed blades (or the blades between the annular plates) serve to create shear and thereby to break the gas into fine
30 bubbles and the treatment agent into fine droplets or particles. However, it has been found that there is a tendency for the bubbles generated to form high concentrations in the periphery of the rotor, that

coalesce and rise rapidly to the surface, carrying the particles or droplets of treatment agent with them, thus reducing the residence time of the treatment agent in the metal . It has been found that by adding the 5 set of upwardly directed radial blades to the rotor, a strong radial flow is generated, forcing the cloud of gas and treatment agent in a outward direction. The tendency to form high local concentrations is then reduced, increasing the average residence time of the 10 treatment agent in the melt. These additional blades also increase the global circulation of liquid metal in the vessel.

In furnaces where the rotary device is mounted on a shaft, and the shaft is oriented at 20 to 40 degrees 15 from the horizontal, it has been found that there is a tendency for the cloud of gas bubbles to be preferentially formed on the side of the rotor closest to the metal surface, and consequently the gas cloud, and associated treatment agent also rises more rapidly 20 to the surface. The use of the further annular plate in accordance with one of the preferred embodiments can overcome this tendency and ensures that the cloud of gas bubbles is more uniformly dispersed around the rotor when configured in this manner.

25 Approximately 3-12 radially directed blades are mounted both above and below the annular plate and six blades on each location have been found to be optimum.

By being able to operate the system while mounted at an angle of about 20-40° to the horizontal, it has 30 the particular advantage of being capable of insertion through an opening in the side of the furnace or, if operating as a mobile unit through a loading door in the furnace. A mobile unit furthermore, can be easily

transported and operated at several furnaces in the cast house.

The treatment system of this invention is well adapted for use in large commercial furnaces, e.g. 5 furnaces having capacities of 10-150 tons. The rotor typically has a diameter of about 25 cm to 50 cm with a rotational speed of about 200-600 rpm. In a typical operation, a salt flux is fed at a rate of 1 kg/min in 200 l/min of carrier gas.

10 The method and apparatus of the invention may be used to treat a variety of molten metals with a particulate treatment agent, for example aluminum and its alloys, magnesium and its alloys, etc. The gas that is used may be inert or it may be reactive to the 15 metal being treated. Examples of gases that may be used include chlorine, argon and nitrogen.

Examples of treatment agents which may be used in particulate form include fluxing agents such as mixtures of alkali metal chlorides for treating 20 aluminum or its alloys, grain refiners, etc.

Brief Description of the Drawings

The invention is illustrated by way of example with reference to the accompanying drawings in which:

Figure 1 is a sectional view of an aluminum-melting furnace with the injector of the invention; 25

Figure 2 is an isometric view of one rotor embodiment;

Figure 3 is a further isometric view of the rotor of Figure 2;

30 Figure 4 is an isometric view of a further rotor embodiment;

Figure 5 is a further isometric view of the rotor of Figure 4;

Figure 6 is a top plan view of the rotor of Figure 4;

5 Figure 7 is a sectional view through the rotor of Figure 4;

Figure 8 is a plan view of the hollow rotor shaft;

Figure 9 is an elevation view of a support frame adapt to carry the rotor; and

10 Figure 10 is an elevation view of a unit for supplying a solids/gas mixture to the rotor.

Best Modes For Carrying Out The Invention

Referring to Figure 1, an aluminum melting furnace 10 has a side opening 11 and contains a bath of molten aluminum 12 with a melt surface 13. Extending through the opening 11 is a hollow rotor shaft 15 having mounted on the end thereof a rotor 16 for dispersing a solids/gas mixture into the molten metal bath 12.

One embodiment of the rotor is shown in greater detail in Figures 2 and 3. It comprises an annular plate 17, typically about 40 cm in diameter, having an axial opening surrounded by a collar 20 for mounting to hollow shaft 15. The plate 17 has an upper face 18 and a lower face 19. Fixed on upper face 18 are a plurality of radially mounted blades 21 having tapered inner end faces 22. The inner ends of these blades are preferable terminated at a radial distance greater than the radius of the collar 20 to provide an annular gap between the collar and the inner edges of the blades. Fixed to the lower face of plate 17 are a further series of radially mounted blades 23 having tapered inner end faces 24. The rotor, in use, is preferably

rotated so that the tapered inner end faces 22 are on the side of the blades opposite the direction of rotation.

With this rotor arrangement the solids/gas mixture 5 pass down through the hollow core 27 of shaft 15 and through collar opening 20 at which point the lower blades 23 serve to mix the solids/gas mixture with the molten metal. Where the solid is a salt flux, it is molten by the point at which it enters the molten 10 aluminum and is readily sheared into small droplets by the blades 23 to effectively distribute them. Because there is a tendency for a cloud of bubbles to be formed by the lower shearing blades 23, and for the treatment agent to remain associated with the cloud of bubbles, 15 the upper blades 21 represent an essential component of the invention. Thus, the upper blades create a secondary mixing of the molten aluminum that serves to disperse any clouds of bubbles that emerge from the region beneath plate 17.

20 A preferred embodiment of the invention is illustrated by Figures 4 to 7. In this embodiment, a second annular plate 25 is mounted directly beneath the lower blades 23, thus creating segment shaped passageways 28 between the plates 17 and 25 and between 25 adjacent radially mounted shearing blades 23 as can be seen in Figure 7. The two annular plates are preferably spaced apart by a distance of from about 12 to 75 mm. This provides a more efficient dispersal of the solids/gas mixture into the molten metal, 30 particular when the rotor is mounted on a shaft whose axis is mounted at the preferred angle of 20 to 40 degrees from the horizontal.

With this arrangement, the molten metal is drawn upwardly through the axial hole 26 in bottom annular plate 25 where it engages the solids/gas mixture travelling down axial opening 27 of shaft 15 with this 5 mixture being dispersed outwardly through the cavities 28 into the main molten bath 12. With this arrangement, the upper mixing blades 21 remain necessary for the purpose of efficiently dispersing clouds of bubbles that still emerge into the bath.

10 A support assembly for carrying the rotor 16 and hollow shaft 15 is shown in Figure 9. This assembly may be conveniently operated as a mobile unit with the rotor passing through a loading door in the furnace or as a fixed unit with the rotor passing through an 15 opening in the side of the furnace. The hollow shaft 15 is connected to a hollow drive shaft 31 which is mounted for rotation on a support 30. This support 30 is pivotally connected by way of pivot 34 to a support frame 33. A tilting mechanism 35 tilts the hollow 20 shaft to the desired angle of 20-40° to the horizontal when in use.

An assembly 36 for mixing and feeding a solids/gas mixture is also mounted on pivotal support 30 and is connected to hollow drive shaft 31 by way of flexible 25 tube 37. This assembly 36, as shown in Figure 10, includes a hopper 40 for particulate solids materials, which feeds into a screw feed 41 and thence into funnel 42 having an outlet 44 connecting to flexible tube 37. A sealed enclosure 43 is charged with the desired gas 30 and the gas feeds through funnel together with the particulate.

The assembly is supported by legs 45 and includes a control panel 46.

The present invention is useful for efficiently reducing alkali metals and particulate in large aluminum melting and holding furnaces. In comparative tests, it has been found that the apparatus can reduce 5 Ca and Na levels by 37 and 30% respectively compared to a simple impeller design as previously used. This permits reduction of fluxing times by a similar amount. Particulate removal rates are at least as good as those obtained using the simple impeller design.

Claims:

1. Apparatus for the treatment of molten metal with a particulate treatment agent and a gas, comprising a vessel for holding molten metal, a rotary device for breaking up particulate treatment agent and gas within molten metal, and for dispersing particulate treatment agent and gas within molten metal within the vessel and means for supplying the particulate treatment agent and gas to the rotary device,

10 wherein the rotary device comprises a hollow shaft having a rotor with an axial opening fixed to the discharge end thereof, said rotor comprising an annular plate with a plurality of radially mounted, upwardly directed blades projecting from the top face of the annular plate and a plurality of radially mounted downwardly directed blades projecting from the bottom face of the annular plate.

2. An apparatus according to Claim 1 wherein a further annular plate is fixed below the radially mounted blades that project downwardly from the said annular plate, whereby the particulate treatment agent and gas are discharged between the annular plates.

3. An apparatus according to Claim 1 or 2 wherein the vessel is an aluminum melting or holding furnace and the rotary device is mounted within the furnace with the axis of the hollow shaft at an angle to the horizontal of about 20-40°.

4. An apparatus according to Claim 1, 2 or 3 installed in a furnace having a capacity of about 10-30 150 tons.

5. An apparatus according to any one of Claims 1-4 wherein the annular plate has 3-12 downwardly directed blades and 3-12 upwardly directed blades.
6. An apparatus according to Claim 5 having six 5 blades on said bottom face and six blades on said top face.
7. An apparatus according to any one of Claims 1-6 wherein the outer ends of the radially mounted blades do not project beyond the outer periphery of the 10 annular plate or plates.
8. A rotary device for the treatment of molten metal comprising a hollow shaft and a rotor with an axial opening fixed to the discharge end thereof, said rotor comprising an upper annular plate and a lower 15 annular plate with a plurality of radially mounted, upwardly directed blades projecting from the top face of the upper annular plate and a plurality of radially mounted blades fixed between said upper and lower annular plates.
9. A process for the treatment of molten metal with a particulate treatment agent and a gas which comprises providing a rotary device comprising a hollow shaft having a discharge end and an annular rotor attached to the shaft, the rotor having a plurality of 25 radially mounted upwardly directed blades and a plurality of radially mounted downwardly directed blades, immersing the rotary device in molten metal contained in a vessel, rotating the device while feeding particulate treatment agent and gas down 30 through the hollow shaft whereby the particulate

treatment agent and gas enter the molten metal beneath the rotor and are broken into droplets and finer particles and dispersed within the molten metal by the shearing action of the downwardly directed blades and
5 further mixing the molten metal by the action of the upwardly directed blades whereby clouds of bubbles formed by action of the downwardly directed blades are dispersed within the molten metal.

10. A process according to Claim 9 wherein the annular rotor includes a further annular plate fixed below the radially mounted blades that project downwardly from said annular plate and the particulate treatment agent and gas are delivered to the molten metal through segment-shaped cavities formed between
15 the annular plates and radially mounted blades.

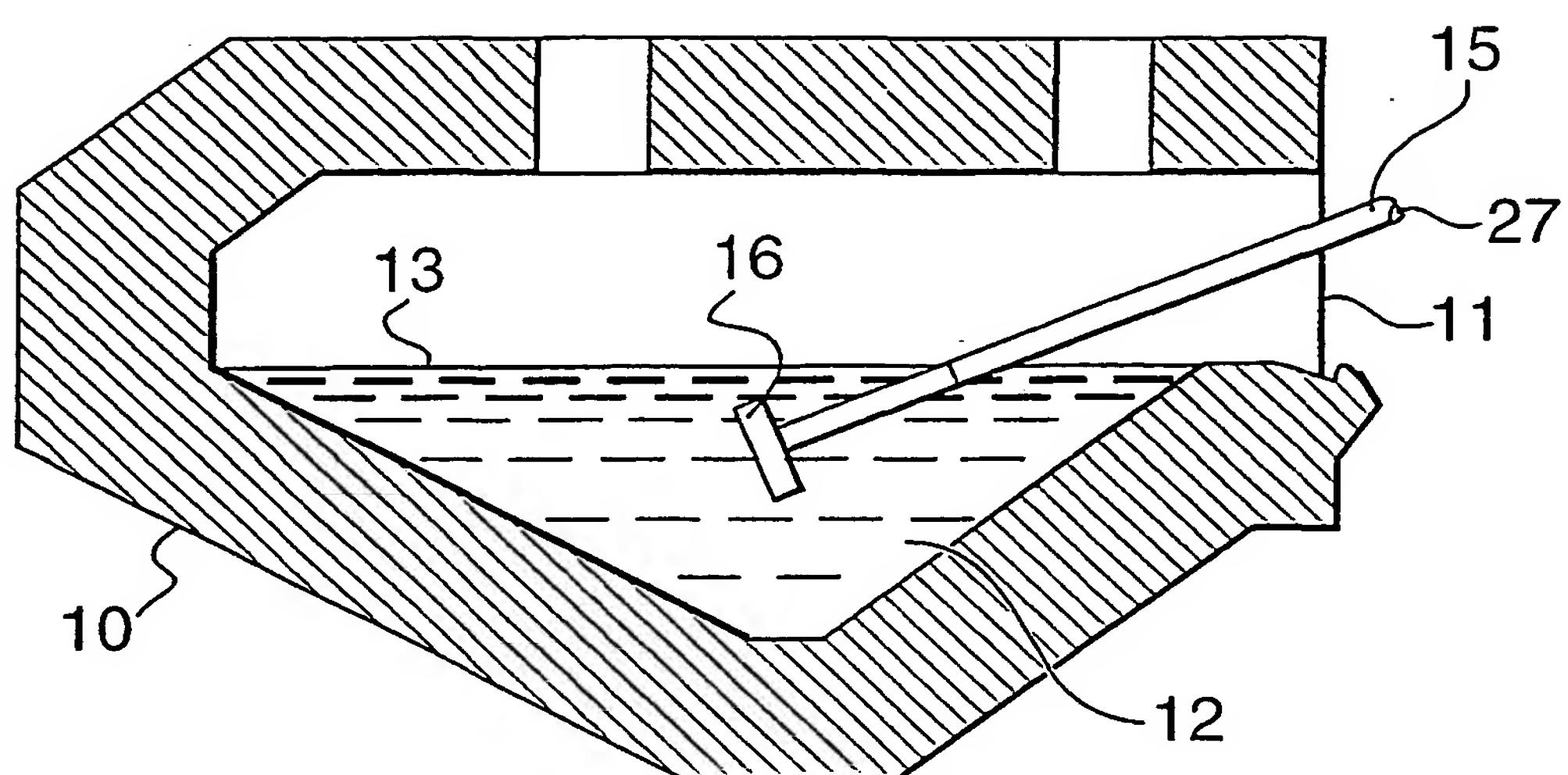
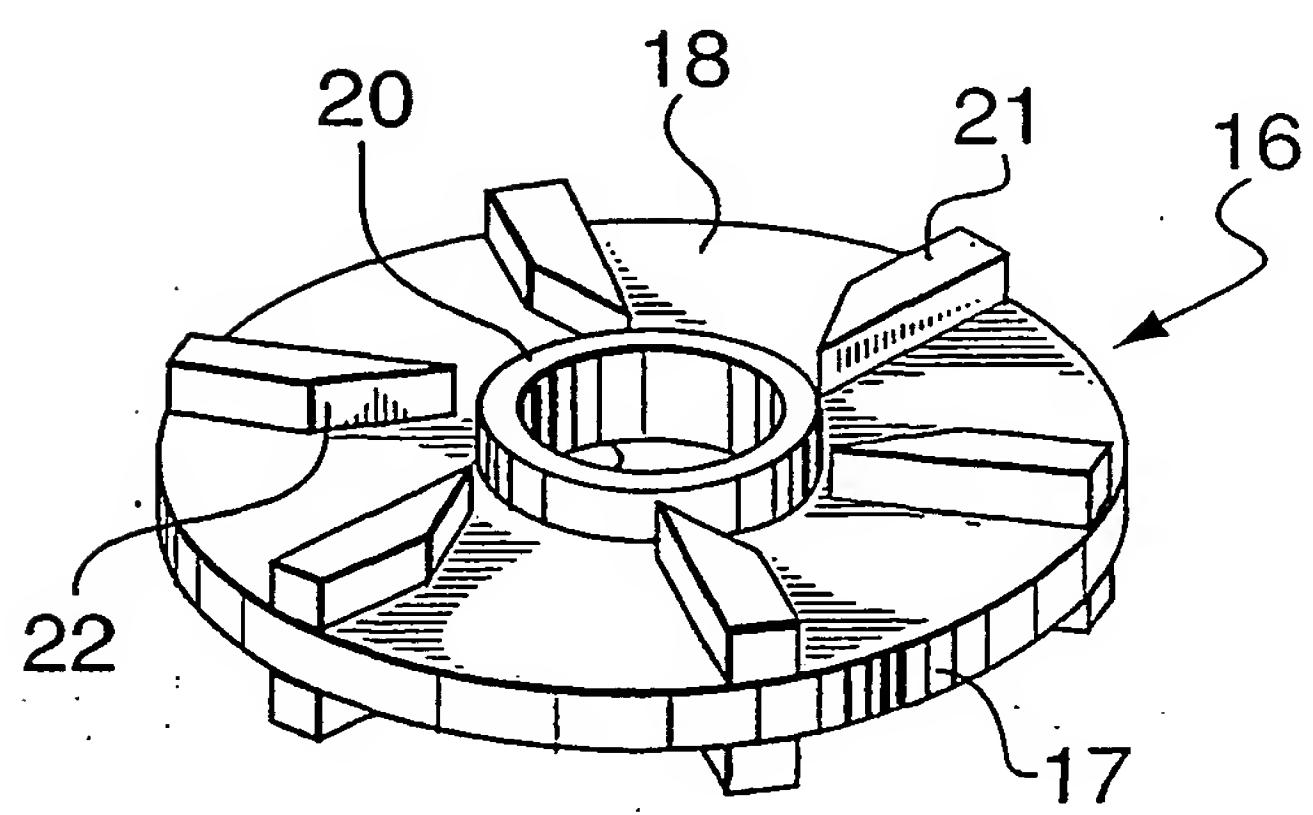
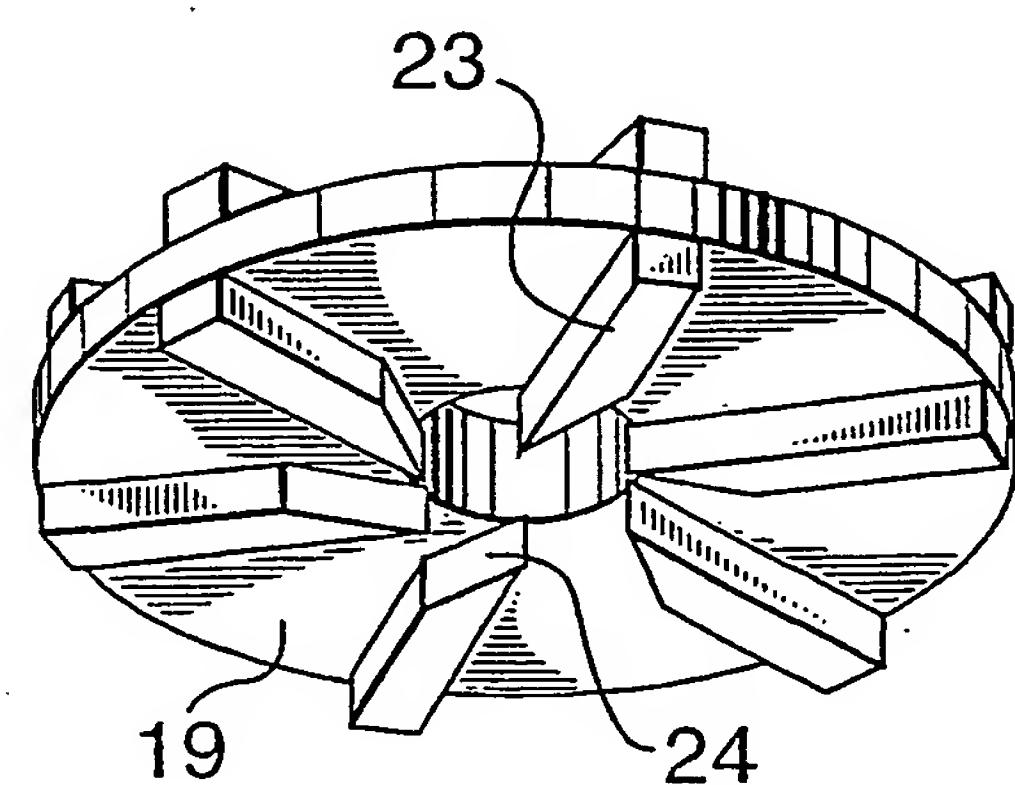
11. A process according to Claim 9 or 10 wherein the rotor is operated within the furnace with the axis of the hollow shaft at an angle to the horizontal of about 20-40°.

20 12. A process according to Claim 11 wherein the rotor is operated within the furnace such that all parts of the rotor are located at least 30 cm from any interior surface of the furnace.

25 13. A process according to any one of Claims 9-12 wherein the molten metal is aluminum or an alloy thereof and the particulate treatment agent is a salt flux.

30 14. A process according to Claim 13 wherein the salt flux is molten by the point at which it enters the molten aluminum.

1/4

**FIG. 1****FIG. 2****FIG. 3**

2/4

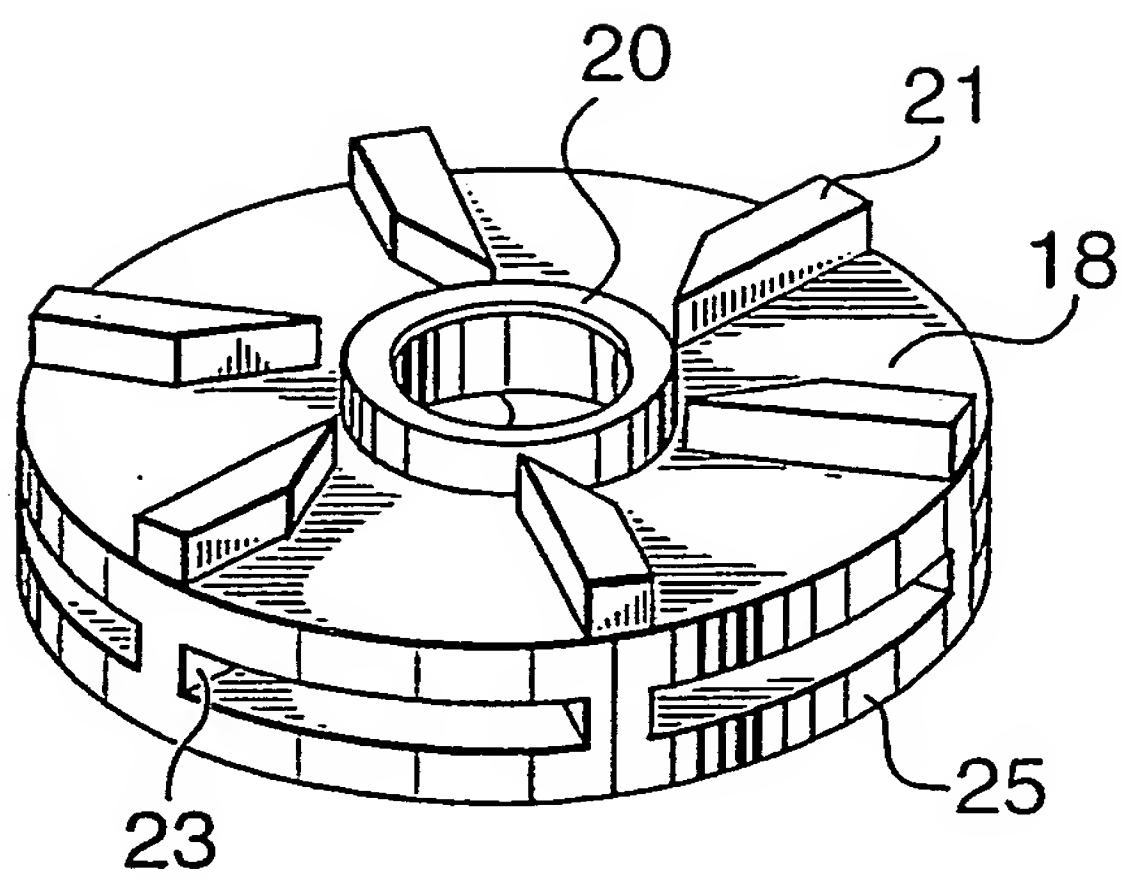


FIG. 4

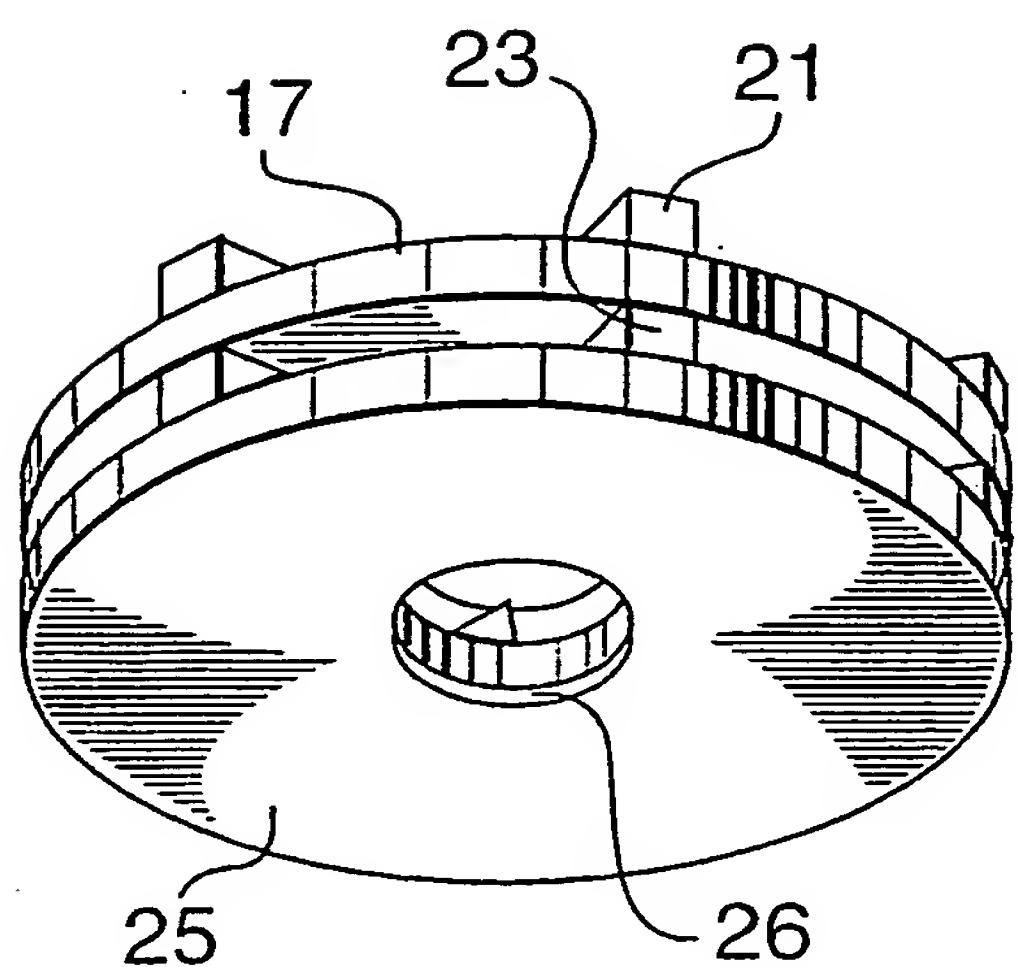


FIG. 5

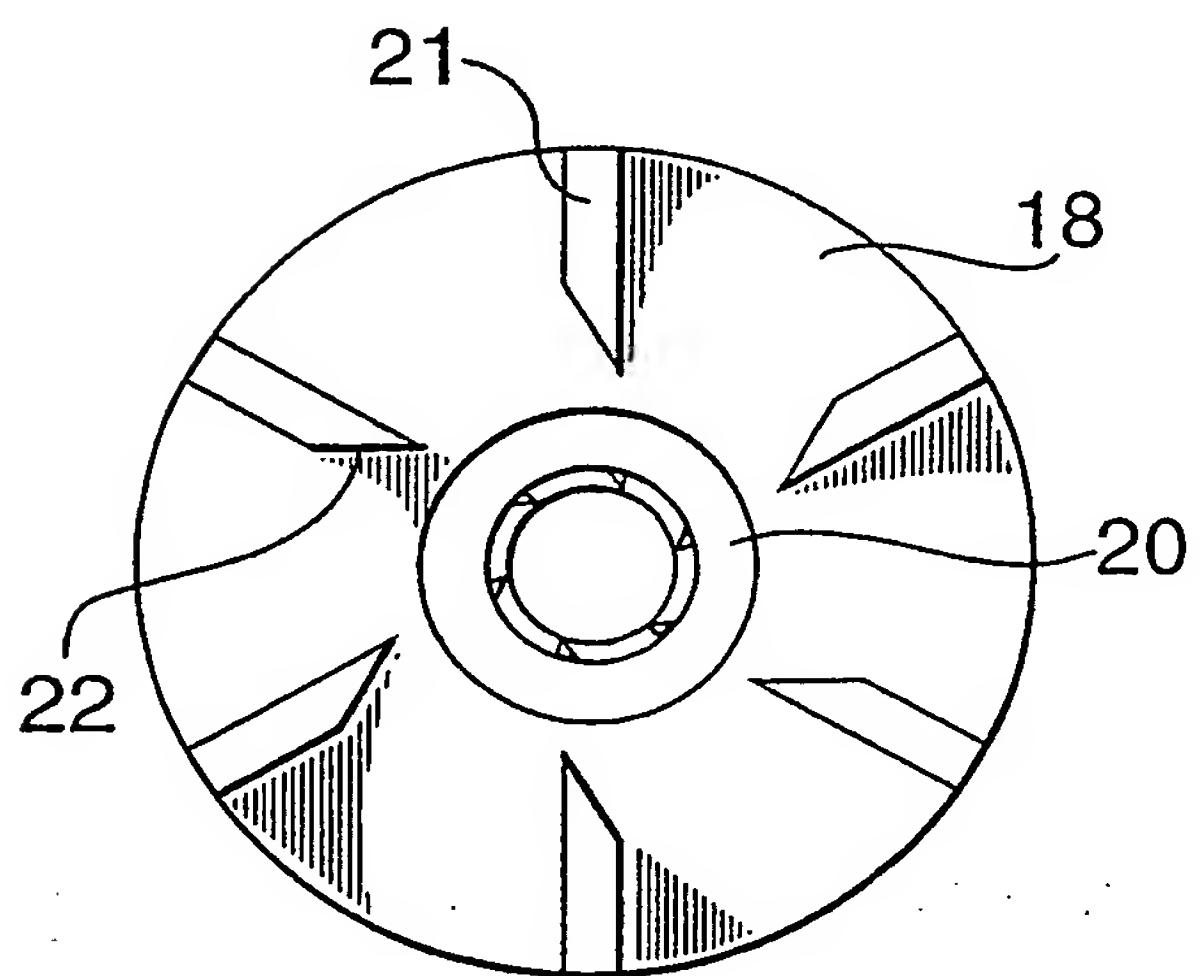


FIG. 6

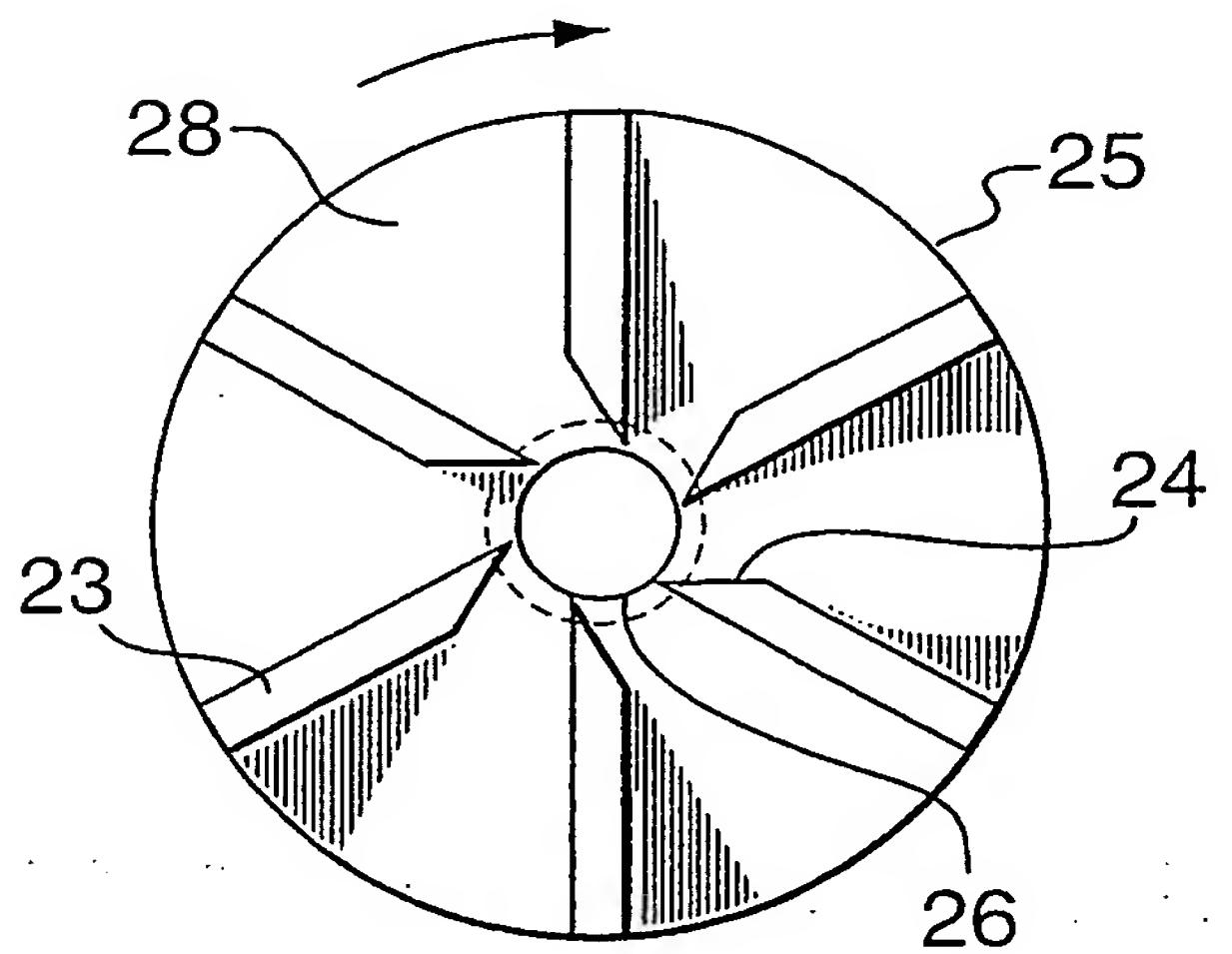


FIG. 7

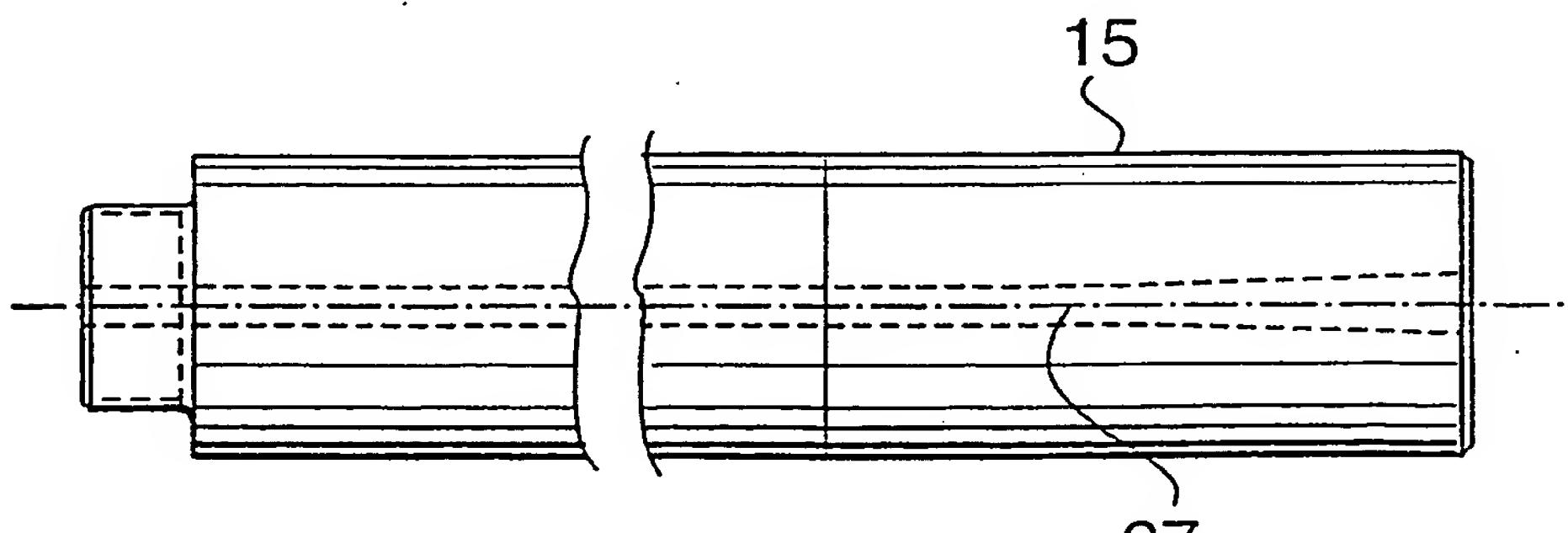
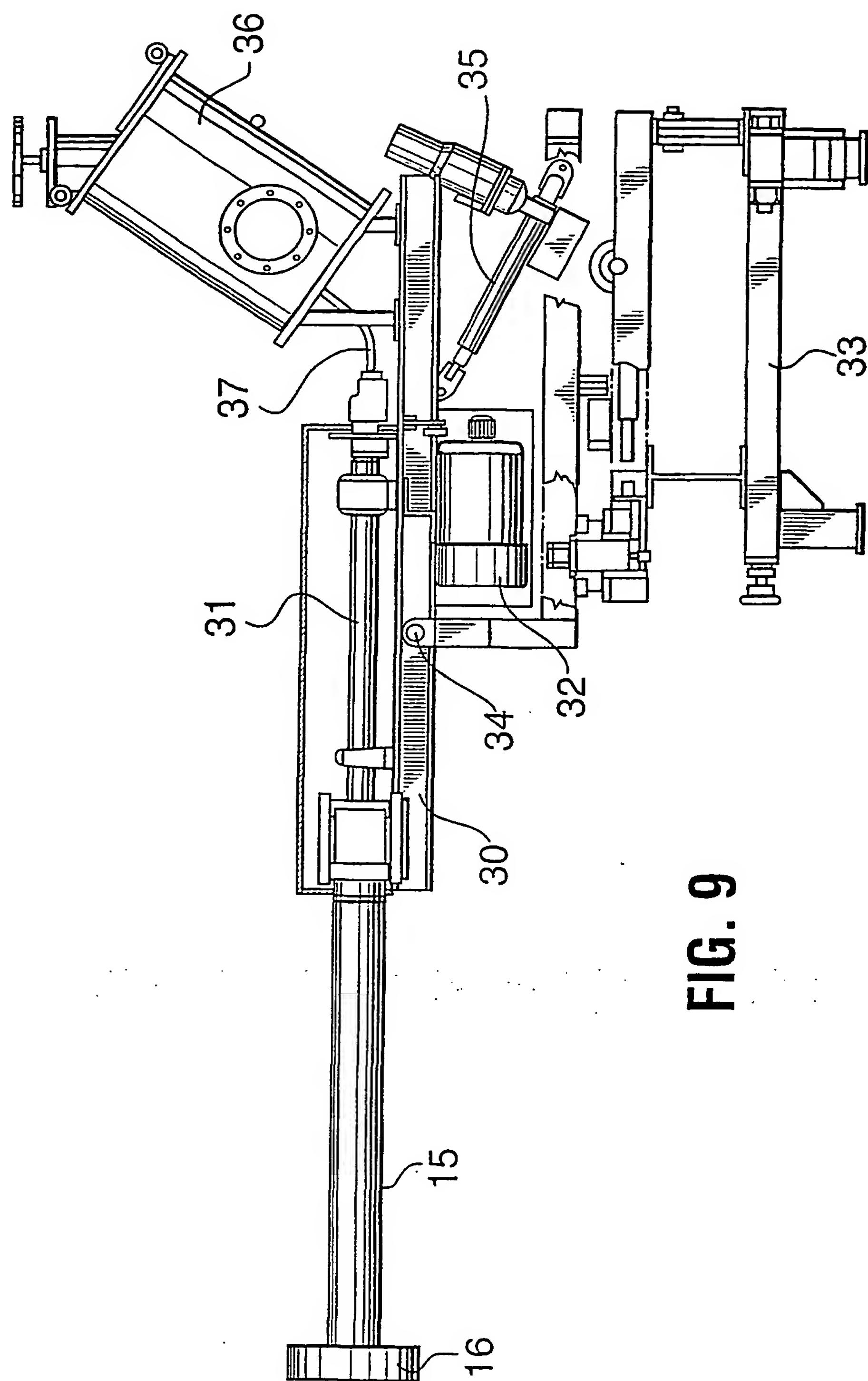


FIG. 8

3/4

**FIG. 9**

4/4

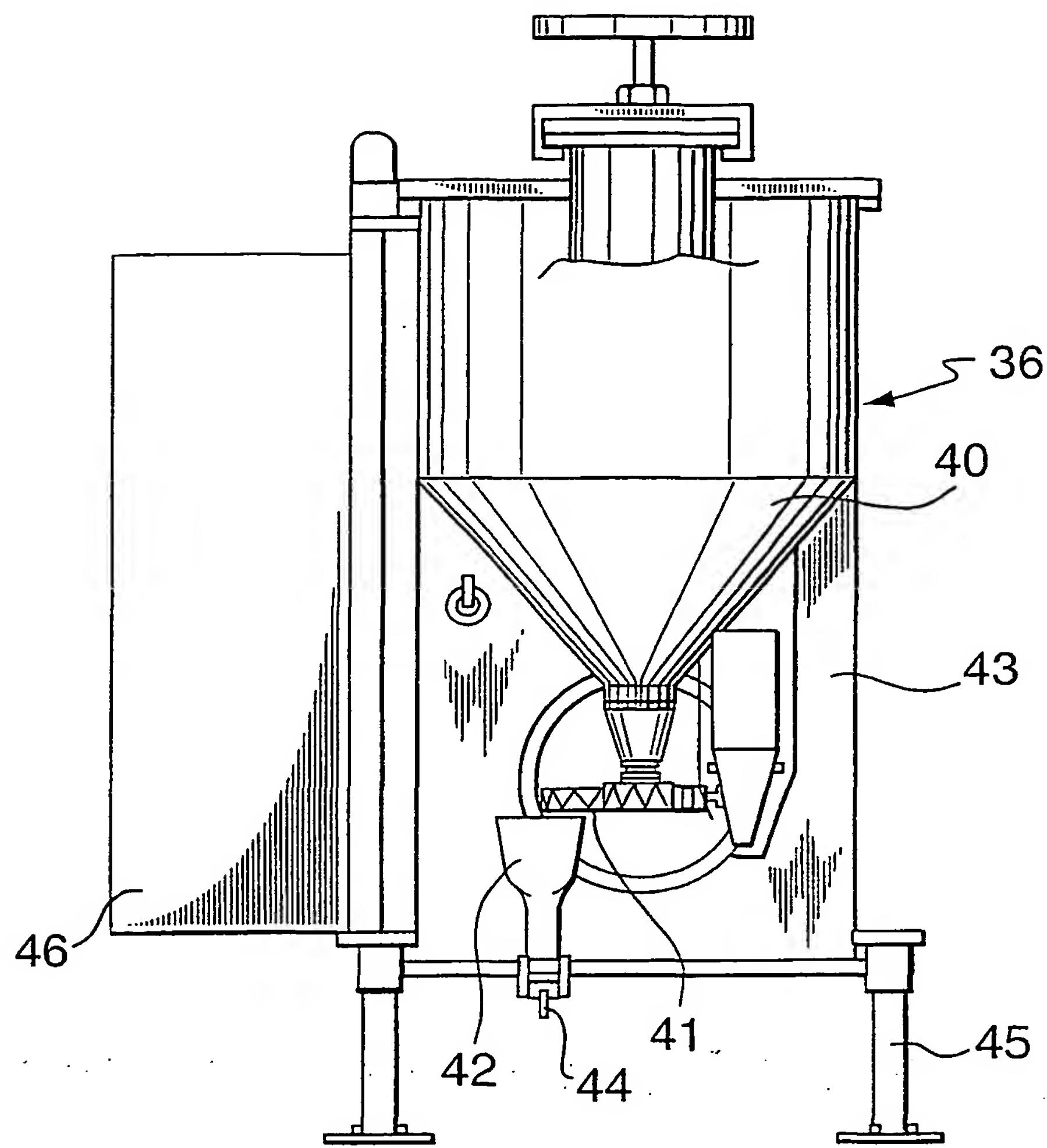


FIG. 10

(19) World Intellectual Property Organization
International Bureau(43) International Publication Date
21 March 2002 (21.03.2002)

PCT

(10) International Publication Number
WO 02/022900 A3(51) International Patent Classification⁷: C22B 21/06, 9/05, 9/10, B01F 3/04, F27D 23/04

(74) Agents: EADES, Norris, M. et al.; Kirby Eades Gale Baker, Box 3432, Station D, Ottawa, Ontario K1P 6N9 (CA).

(21) International Application Number: PCT/CA01/01293

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PH, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.

(22) International Filing Date:

10 September 2001 (10.09.2001)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

60/232,071 12 September 2000 (12.09.2000) US

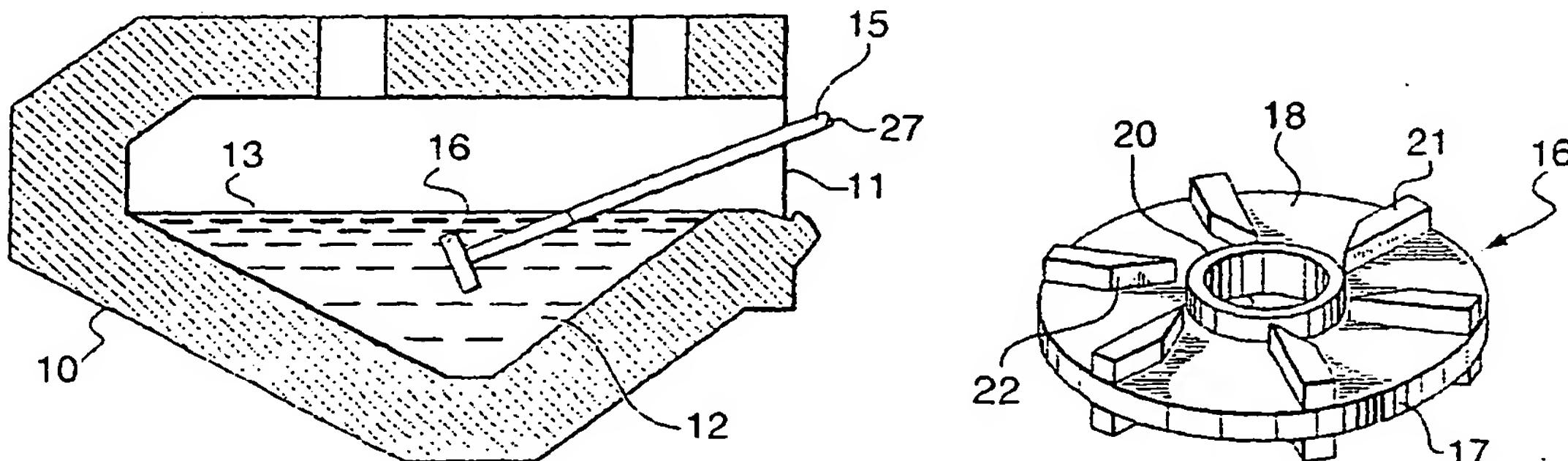
(84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).(71) Applicant (*for all designated States except US*): ALCAN INTERNATIONAL LIMITED [CA/CA]; 1188 Sherbrooke Street West, Montreal, Québec H3A 3G2 (CA).**Published:**

— with international search report

(72) Inventors: and

(75) Inventors/Applicants (*for US only*): BIODEAU, Jean-François [CA/CA]; 3597, Angers, Jonquiere, Québec G7X 2E2 (CA). KISS, Laszlo, Istvan [CA/CA]; 130 rue Marco, Chicoutimi, Québec G7G 4T3 (CA). LAKRONI, Carl [CA/CA]; 129, Panoramique, Chicoutimi, Québec G7J 1H7 (CA).(88) Date of publication of the international search report:
28 August 2003*[Continued on next page]*

(54) Title: PROCESS AND ROTARY DEVICE FOR ADDING PARTICULATE SOLID MATERIAL AND GAS TO MOLTEN METAL BATH

**WO 02/022900 A3**

(57) Abstract: An apparatus is provided for the treatment of molten metal, e.g. aluminum, with a particulate treatment agent and a gas. This includes a vessel for holding molten metal, a rotary device for breaking up particulate treatment agent and gas within the molten metal and for dispersing particulate treatment agent and gas within the molten metal contained in the vessel and means for supplying the particulate treatment agent and gas to the rotary device. The rotary device includes a hollow shaft having a rotor with an axial opening fixed to the discharge end of the shaft, this rotor being in the form of an annular plate with a plurality of radially mounted upwardly directed blades projecting from the top face of the annular plate and a plurality of radially mounted downwardly directed blades projecting from the bottom face of the annular plate.



For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

INTERNATIONAL SEARCH REPORT

International Application No

PCT/CA 01/01293

A. CLASSIFICATION OF SUBJECT MATTER	IPC 7 C22B21/06	C22B9/05	C22B9/10	B01F3/04	F27D23/04
-------------------------------------	-----------------	----------	----------	----------	-----------

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C22B B01F F27D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

WPI Data, EPO-Internal, PAJ, COMPENDEX

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 6 060 013 A (BERTRAND JOEL ET AL) 9 May 2000 (2000-05-09) abstract; figures 3B,4 ---	1-14
Y	US 5 342 429 A (YU HO ET AL) 30 August 1994 (1994-08-30) abstract; figure 1 ---	1-14
Y	US 3 849 119 A (BRUNO M ET AL) 19 November 1974 (1974-11-19) claims 1-3; figure 2 ---	1,2,8,9
Y	EP 0 753 589 A (STRIDE STEVEN) 15 January 1997 (1997-01-15) claims 1-5,9,10; figure 4 ---	1,2,8,9
		-/-

 Further documents are listed in the continuation of box C. Patent family members are listed in annex.

* Special categories of cited documents :

- *A* document defining the general state of the art which is not considered to be of particular relevance
- *E* earlier document but published on or after the international filing date
- *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- *O* document referring to an oral disclosure, use, exhibition or other means
- *P* document published prior to the international filing date but later than the priority date claimed

- *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- *&* document member of the same patent family

Date of the actual completion of the international search

19 April 2002

Date of mailing of the international search report

29/04/2002

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl.
Fax: (+31-70) 340-3016

Authorized officer

Bombeke, M

INTERNATIONAL SEARCH REPORT

International Application No

/CA 01/01293

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 4 673 434 A (WITHERS CHRISTOPHER J ET AL) 16 June 1987 (1987-06-16) figures 1-4 ---	1,2,8,9
Y	US 3 227 547 A (SZEKELY ANDREW G) 4 January 1966 (1966-01-04) column 2, line 49 - line 54 column 4, line 3 - line 28; figures 18,14,15 ---	1-14
Y	US 5 616 167 A (ECKERT C EDWARD) 1 April 1997 (1997-04-01) figures 2,4-9 ---	1-14

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/CA 01/01293

Patent document cited in search report		Publication date		Patent family member(s)		Publication date
US 6060013	A	09-05-2000	AU DE EP WO	714284 B2 3853397 A 69700963 D1 69700963 T2 916066 T1 0916066 A1 9805915 A1		23-12-1999 25-02-1998 20-01-2000 08-06-2000 21-10-1999 19-05-1999 12-02-1998
US 5342429	A	30-08-1994	AU BR CA EP JP NO	6070394 A 9401882 A 2122421 A1 0623685 A1 7126769 A 941549 A		10-11-1994 29-11-1994 06-11-1994 09-11-1994 16-05-1995 07-11-1994
US 3849119	A	19-11-1974	US	3767382 A		23-10-1973
EP 0753589	A	15-01-1997	EP	0753589 A1		15-01-1997
US 4673434	A	16-06-1987		NONE		
US 3227547	A	04-01-1966		NONE		
US 5616167	A	01-04-1997	US	5630863 A 5462581 A 5364450 A 5718742 A 5772725 A 5968223 A 699005 B2 7360994 A 2166687 A1 69421296 D1 69421296 T2 0786015 A1 9502707 A1 US		20-05-1997 31-10-1995 15-11-1994 17-02-1998 30-06-1998 19-10-1999 19-11-1998 13-02-1995 26-01-1995 25-11-1999 18-05-2000 30-07-1997 26-01-1995 31-10-1995

**This Page is Inserted by IFW Indexing and Scanning
Operations and is not part of the Official Record**

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images include but are not limited to the items checked:

BLACK BORDERS

IMAGE CUT OFF AT TOP, BOTTOM OR SIDES

FADED TEXT OR DRAWING

BLURRED OR ILLEGIBLE TEXT OR DRAWING

SKEWED/SLANTED IMAGES

COLOR OR BLACK AND WHITE PHOTOGRAPHS

GRAY SCALE DOCUMENTS

LINES OR MARKS ON ORIGINAL DOCUMENT

REFERENCE(S) OR EXHIBIT(S) SUBMITTED ARE POOR QUALITY

OTHER: _____

IMAGES ARE BEST AVAILABLE COPY.

As rescanning these documents will not correct the image problems checked, please do not report these problems to the IFW Image Problem Mailbox.